

Date: Thursday, 07/12/2006 6:55:36 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 29769		Part Number	: D1048		
Estimate Number	: 10584		Drawing Number	: D1048 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 07/12/2006	S.O. No.	: N/A		Drawing Revision	: A
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 15/01/2007		
Previous Run	: 29769		Qty:	50	Um:	Each
Written By	: <u> </u>					
Checked & Approved By	: <u> </u>					
Comment	: Est: B 02.02.22 Re-format NG Est Rev:C Now on Waterjet 06-12-06 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.0116 sf(s)/Unit Total : 0.5775 sf(s) 304/316 .063 Sheet Batch: M101873 <i>ml 07/01/05</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D1048 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <i>ml 01 01 09</i>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>ml 01 01 09</i>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>ml 07/01/09 (50)</i>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg. <i>SB P.M. 11-01-07 (50)</i>		

Date: Thursday, 07/12/2006 6:55:36 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 29769

Part Number: D1048

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2010 using DT8053

FF 07-01-26 49

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/01/29 49

8.0 POWDER COATING POWDER COATING



M100700



49x

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m.b/a.m

07/01/31

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 11/02/06 (49)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 11/02/06 (49)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



107/02/07 (49)

Job Completion



107/02/07

Date: Tuesday, 12/5/2006 8:14:16 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 29769		Part Number	: D1048		
Estimate Number	: 10584		Drawing Number	: D1048 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 12/5/2006		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 1/15/2007		
Previous Run	: 27091		Qty:	50	Um:	Each
Written By	:		12/06/05			
Checked & Approved By	:					
Comment	: Est: B 02.02.22		Re-format NG			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  Comment: PURCHASING Issue P/O: _____ Stamp and deburr per dwg D1048 Material: Stainless steel T304#2B Supply release not for Material.
2.0	D1048F	Clamp  Comment: Qty.: 1.0000 U(s)/Unit Total : 50.0000 U(s) CLAMP
3.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK  Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg. 2-Form as per dwg D2010 using DT8053

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: ND Date: 07/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/07	2.0	DXF Program was wrong holes were 1.38 center to center, but were supposed to be 1.705	<u>J</u> QS1042	Fix Program , Destroy Peices and re-cut	<u>E</u> 07.01.07 <u>M</u> 07/01/07	<u>J</u> 07/01/07	<u>J</u> QS1042	<u>J</u> 07/01/07
07/01/07	6.0	Bracket off centre	<u>J</u> QS1042	SCRAP + Destroy No replace.	<u>FF</u> 07/01/07	<u>J</u> 07/01/07	<u>J</u> QS1042	<u>J</u> 07/01/07

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 29769

Part Number: D1048

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 29769

Description: Clam

Part Number: D1048

Inspection Dwg: D1048 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:

W.L.M.

Audited by:

三

Prototype Approval:

Date: _____

07 01 09

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	